

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027823**Date Inspected:** 24-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1930**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Ultrasonic Testing of ESW

This QA performed Ultrasonic Testing (UT) on approximately 3700mm of Tower Electroslag Complete Joint Penetration (CJP) shear plate weld designated as "ESW G". Location (Y=6100~9800) of this weld was inspected using this testing method.

This weld was previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3.

This QA observed three (3) recordable indications approximately at the time of testing. These indications were recorded by QC technicians prior to QA performing this testing. This QA generated a TL-6027 UT report on this date.

The following indications were observed as having a transverse orientation. Due to joint configuration and weld cap shape these indications could not be evaluated for length or "X" location.

Indication #1: Y= 8750mm

Sizing – A= 81db, B= 55.5db, C= 8db, D= 18db

Sound Path= 128.1mm, Depth= 49mm

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Indication #2: Y= 8600mm

Sizing – A= 83.5db, B= 55.5db, C= 7db, D= 21db

Sound Path= 109.1mm, Depth= 38mm

Note: This location appeared to be a grouping of two (2) or more transverse indications.

Indication #3: Y= 7450mm

Sizing – A= 80.5db, B= 55.5db, C= 7db, D= 18db

Sound Path= 117.4mm, Depth= 41mm

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations were relevant to testing performed and indications discovered during excavation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
